



Dart Aerospace Ltd.
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D3370-3

Job Sheet 181695



Part No: D3370-3

Job Qty: 2 ea

Part Name: Pedal Lock Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/4/18

Job Tracking No:

Due Date: 8/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP B 05.05.25 Added Powder Coat KJ/JLM IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/24/18	8/24/18	0.00	0.00	Start Up Machining-2		DJP 18-9-8
100	Bandsaw	2 pcs	8/24/18	8/24/18	0.00	0.07	Bandsaw1		DJP 18-9-8
110	CNC Vertical Machining	2 pcs	8/24/18	8/24/18	0.00	1.90	HAAS1-3		DJP 18-9-8
120	QC	2 pcs	8/24/18	8/24/18	0.00	0.00	QC2 Machining-2		DJP 18-9-8
130	QC	2 pcs	8/24/18	8/24/18	0.00	0.00	QC8 Machining-2		Kt 2018-09-10
140	HandFinish	2 pcs	8/24/18	8/24/18	0.00	0.26	HandFinish1		SA 18-09-10
150	Powdercoat	2 pcs	8/24/18	8/24/18	0.00	0.11	Powdercoat6		SA 18-09-10
160	QC	2 pcs	8/24/18	8/24/18	0.00	0.00	QC3		SEP 18 2018 68
170	Packaging	2 pcs	8/24/18	8/24/18	0.00	0.00	Packaging3-1		SEP 18 2018 9-89
180	QC21-SA	2 Ea	8/24/18	8/24/18	0.00	0.00	QC21		SEP 18 2018 9-89

Part Op 100 - Cut blank: 1.500" x 2.500" x 4.120" long

Descriptions: 110 - Machine D3370-3 as per Folio FA483 and Dwg D3370 Identify as D3370-3

150 - Heat oven at temperature for 45 minutes before putting part in oven by:

M 129223 START 3:30

OUT: 3:00 FIN 13:14 4:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	.6966 ft (.3483 ea)	90-Start up Operation	S052630

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.500	1	25	0



Container No: S108586



Part: D3370-3
Job No: 181695
Serial No/Batch: S108586

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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CANADA
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Part Specifications

Specifications could not be found.

Plex 8/7/18 7:32 AM Dart.lajeunesse.marie

Date: 09/09/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>181695</u> Part No. <u>D3370-3</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
Date: <u>18/09/07</u>		Step #: <u>OP #3</u>		QTY Effective: <u>1</u>		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
Tool didn't hold in spindle and dropped on part resulting in damaging part and tool				Fixed tool carousel			
				Completed By SC DAS 52 18/09/07 Lead hand / Supervisor Approval Verification [Signature] 18/09/07			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☒ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☒ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐			
OTHER: _____							

DART AEROSPACE LTD		Work Order: 181695
Description: Pedal Lock Cover		Part Number: D3370-3
Inspection Dwg: D3370	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.996	✓		Ver	
3.344	+/-0.010	3.346	✓		Ver	
0.592	+/-0.010	.594	✓		Ver	
0.202	+/-0.010	0.200	✓		Ver	
Ø1.000	+0.005/-0.000	Ø 1.001	✓		Ver	
0.25	+/-0.030	0.255	✓		Ver	
2.000	+/-0.010	2.000	✓		Ver	
0.300	+/-0.010	0.305	✓		Ver	
0.550	+/-0.010	0.550	✓		D.G.	
1.50	+/-0.030	1.505	✓		Ver	
Ø1.250	+0.005/-0.000	1.251	✓		Ver	
0.635	+0.010/-0.000	0.635	✓		Ver	
Ø0.750	+0.010/-0.000	Ø .757	✓		Ver	
1.673	+/-0.010	1.668	✓		Ver	
0.430	+/-0.010	.433	✓		Ver	
2.638	+/-0.010	2.634	✓		Ver	
2.35	+/-0.030	2.350	✓		Ver	
0.715 deep	+/-0.010	.715	✓		D.G.	
15°	+/-0.1°	15°	✓		A.F	
0.19 x 45°	+/-0.030	0.19 x 45°	✓		Ver	
0.450	+/-0.010	0.450	✓		Ver	
1.450	+/-0.005	1.450	✓		Ver	

Measured by: DAS 52 [Signature]	Audited by: DAS 1 [Signature]	Preliminary Approval:
Date: 8/09/07	Date: 2018-09-10	Date:

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	
D	10.04.20	Dimensions revised per Dwg Rev C	KJ [Signature]	[Signature]